

Work Order ID 135244

August 06, 2015 2:22:36 PM

Orders to ship Aug 21 or sooner Aug 14th

135244

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Item ID: D206-628-022

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear 206L/L1/L3/L4

Stop ***NS2***

Start Date: 8/6/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 8/20/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals:

Process Plan: *SH*

Date: *20150808*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A		JA						SH 15-08-07
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-022 CHG 003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

AUG 19 2015

DAS
6
9-89

③ JA

AUG 07 2015

27
9-89

DAS
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AUG 19 2015

DAS
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AUG 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Item ID: D206-628-022

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear 206L/L1/L3/L4

Start Date: 8/6/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 8/20/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-022
Location : FG081

3 15/08/21 SP

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

ML5 AUG 21 2015

MF
15-8-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 135244

135244

Parent Item: D206-628-022

D206-628-022

Parent Item Name: Heli-Access-Step™ RH - High Gear 206L/L1/L3/L4

Start Date: 8/6/2015

Required Date: 8/20/2015

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:D as per ECN 766 JLM
 IPP Rev:E as per ecn 1118 DD verified by:EC
 10.08.13 CHG QTY OF RUBBER DD verf by:EC
 IPP Rev:F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2724-042		Manufactured	No				Each	0.0000		3			
D2724-042									**	135242			
206L Step Assembly, RH													
NAS1149D0463J		Purchased	No				Each	3,314.000		36			
NAS1149D0463J									**	JA.			
WASHER													

Location	Loc Qty	Loc Code
GA	41	
M129390	41	
ST260a	1000	
M132677	1000	
ST269	2273	
M127904	20	
M129682	86	
M130799	371	
<u>M132035</u>	1671	
M132317	125	

AN4-14A		Purchased	No				Each	211.0000		12			
AN4-14A									**	JA.			
Bolt													

Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST325A	100	
M132677	100	
ST344	106	
<u>M132640</u>	106	

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Work Order ID: 135244

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Parent Item: D206-628-022

D206-628-022

Parent Item Name: Heli-Access-Step™ RH - High Gear 206L/L1/L3/L4

Start Date: 8/6/2015

Required Date: 8/20/2015

Start Qty: 3.00

Required Qty: 3.00

AN4-15A

Purchased No

120

Each

275.0000

24

AN4-15A

Bolt

**

JA

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Location

Loc Qty

Loc Code

GA

40

120449

40

ST325A

235

m128978

8

m132317

27

m132551

200

D2731-7

Manufactured No

120

Each

38.0000

12

D2731-7

Mounting Lug

**

JA

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DAS
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Location

Loc Qty

Loc Code

ST520

38

132234

14

132444

24

D2732-030

Manufactured No

120

Each

80.0000

8 24

D2732-030

Rubber Cushion - 3"

qty 8 x 3" per kit

**

JA

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DAS
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Location

Loc Qty

Loc Code

FG

34

134608

34

ST410

46

133074

46

8117118

24

Picklist Print

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Work Order ID: 135244

135244

Parent Item: D206-628-022

D206-628-022

Parent Item Name: Heli-Access-Step™ RH - High Gear 206L/L1/L3/L4

Start Date: 8/6/2015

Required Date: 8/20/2015

Start Qty: 3.00

Required Qty: 3.00

D3394-043

Manufactured No

120 Each

72.0000 4 12

D3394-043

Lug

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**

JA

27
9-89

Location

Loc Qty

Loc Code

ST528

72

131774

16

132499

26

134677

30

MS21042L4

Purchased No

120 Each

2,928.000 12 36

MS21042L4

Locknut

DAS
6
9-89

**

JA

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Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

134

m127813

134

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2622

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2430

36

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-
STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE